Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32635
Estimate Number : 10262
P.O. Number : N/A
This Issue : 5/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 32265
Written By :
Checked & Approved By : 07.05.28
Comment : Est Rev:I 02.09.25 Rearranged procedure stepsKJ
Est Rev:J 06-03-23 As per Rev D JLM
Est Rev:J 06-07.13 As per dsi9343 EC

Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Part Number : D350636011
Drawing Number : D2750 ~~UNDER REVIEW~~ CB 07.05.28
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 6/20/2007 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-011 CHG 002 See attached

2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	D32448

7-6-15

3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch B29784 BE 07-07-17

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

7-6-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ________ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635
Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :

as per dwg D2750.

4-Drill pilot holes for Detail B using DT8330 R 7-6-15

5-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube******

7-Open up holes of Detail A to 0.250" (total of 2 holes per side)

8- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

R 7-6-18

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M 104221 BE 07-07-17

10-Grind welds flush as per Dwg D2750

11-Countersink Detail A as per dwg D2750.

12- Scribe batch# inside per dwg D2750

R 7-7-19

Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — 07/07/20

6.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP — Ep 07/07/20

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 — AWM 07/27/24

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION — Ep 07/07/24

Form: mprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	D2739	350 I Beam
Comment:	Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Web Batch: B33062	R 7-7-24
10.0	D34901	CROSS BOLT SPACER
Comment:	Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Crossbolt spacer Batch: B32293	BF 7-7-25
11.0	D34903	CROSS BOLT SPACER
Comment:	Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Crossbolt spacer Batch: B33074	BF 7-7-25
12.0	D2743	Crossbolt Spacer
Comment:	Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Crossbolt Spacer Batch: B31696	BF 7-7-25
13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail D to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Chamfer holes of Detail V, Detail C, Detail D and hole size "W" per dwg D2750 (welding instructions on sheet 4)

4-Deburr and blow out all chips from inside of tube

R 7-7-24

6-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: M104732
exp. date: 8-1-1

R 7-7-24

7- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:28:16 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
	(welding instructions on sheet 4) A/R Aluminum Rod batch: M104907 BE 7-7-25 8-Grind welds flush as per Dwg D2750 9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 } K 7-7-30 10-Deburr holes	
14.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	07/07/30
15.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/7/30
16.0	POWDER COATING	POWDER COATING
	M105068	(1X)
	Comment: POWDER COATING Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	07/08/08 PRESS WASH BR 07-08-07
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION Inspect for foreign object per QSI 024	FL 07/08/16 (1)
18.0	NAS1330S3KB166	INSERT
	Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s) INSERT Batch: M105039	
19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Install inserts as per Dwg D2750	07-08-16 (1)
20.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP Inspect Inserts	07/08/16

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
21.0	D26483	Wearpad

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Wearpad
Batch: B29777 => x1 B31695 => x4

Seq. #:	Machine Or Operation:	Description :
22.0	D265613	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: B32653

Seq. #:	Machine Or Operation:	Description :
23.0	D265635	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: B30554

Seq. #:	Machine Or Operation:	Description :
24.0	D2746	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearplate
Batch: B33014ɸ

Seq. #:	Machine Or Operation:	Description :
25.0	D2745	Bushing

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Bushing
Batch: B31697

Seq. #:	Machine Or Operation:	Description :
26.0	D3488041	BLADE FITTING ASSEMBLY, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade Fitting, LH
Batch: B32232

Seq. #:	Machine Or Operation:	Description :
27.0	D3492041	PLUG ASSEMBLY

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
* Batch: B32598 07-08-16 (K1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
28.0	D3492043	PLUG ASSEMBLY
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) PLUG ASSEMBLY Batch: B30569	
29.0	AN3C5A	Bolt
	Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s) Bolt Batch: M104885	
30.0	AN3C6A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Bolt Batch: M103693	
31.0	AN3C7A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) BOLT Batch: M103668	
32.0	AN6C44A	BOLT
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) BOLT Batch: M103964 (X2) M104937 (X2)	
33.0	AN8C35A	BOLT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BOLT Batch: M102671	
34.0	AN960C10L	washer
	Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s) washer Batch: M105143 07-08-16 (X1)	

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635 | Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
35.0	AN960C816L	WASHER

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: M104093

36.0	MS210436	NUT

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
NUT
Batch: M103693

37.0	MS21083C8	NUT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
NUT
Batch: M104625

38.0	NAS1515H3L	WASHER

Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)
WASHER
Batch: M104603

39.0	NAS1515H8L	WASHER

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
WASHER
Batch: M104927

40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M105085

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M104989
EXP DATE: 08-01

07-08-16 09-08-16 X1

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Friday, 5/25/2007 8:28:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635 **Part Number:** D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
	4-Coat all exposed fasteners with "LPS Procyon" batch: M104251	07-08-16
41.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	Ep 07/08/16
42.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
43.0	D2741	Blade
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Blade Batch: B32583	SP
44.0	AN960C816L	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M104093	SP
45.0	MS21083C8	NUT
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut Batch: M104625	SP
46.0	AN8C21A	BOLT
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: M105107	SP
47.0	NAS1515H8L	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: M104955	SP 7/8/10

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: __________________ PAR #: ______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 32635

Part Number: D350636011

Job Number:

Seq. #:	Machine Or Operation:	Description :
48.0	D34931	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) WASHER Batch: B 32600	SP
49.0	D35321	spacer
	Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s) batch: B27894	7/8/10 SD
50.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	09/08/17
51.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Package as per PPP D350-636-011	REVIE 07/08/17 SP
52.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07.08.20

Job Completion

07-08-17

B32635

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: _______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2750 REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS

A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157

RELEASED 06.02.07

UNDER REVIEW 07.02.05 CB — OK CB

add gaskets change to SS wearplates

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 32635

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

UNDER REVIEW

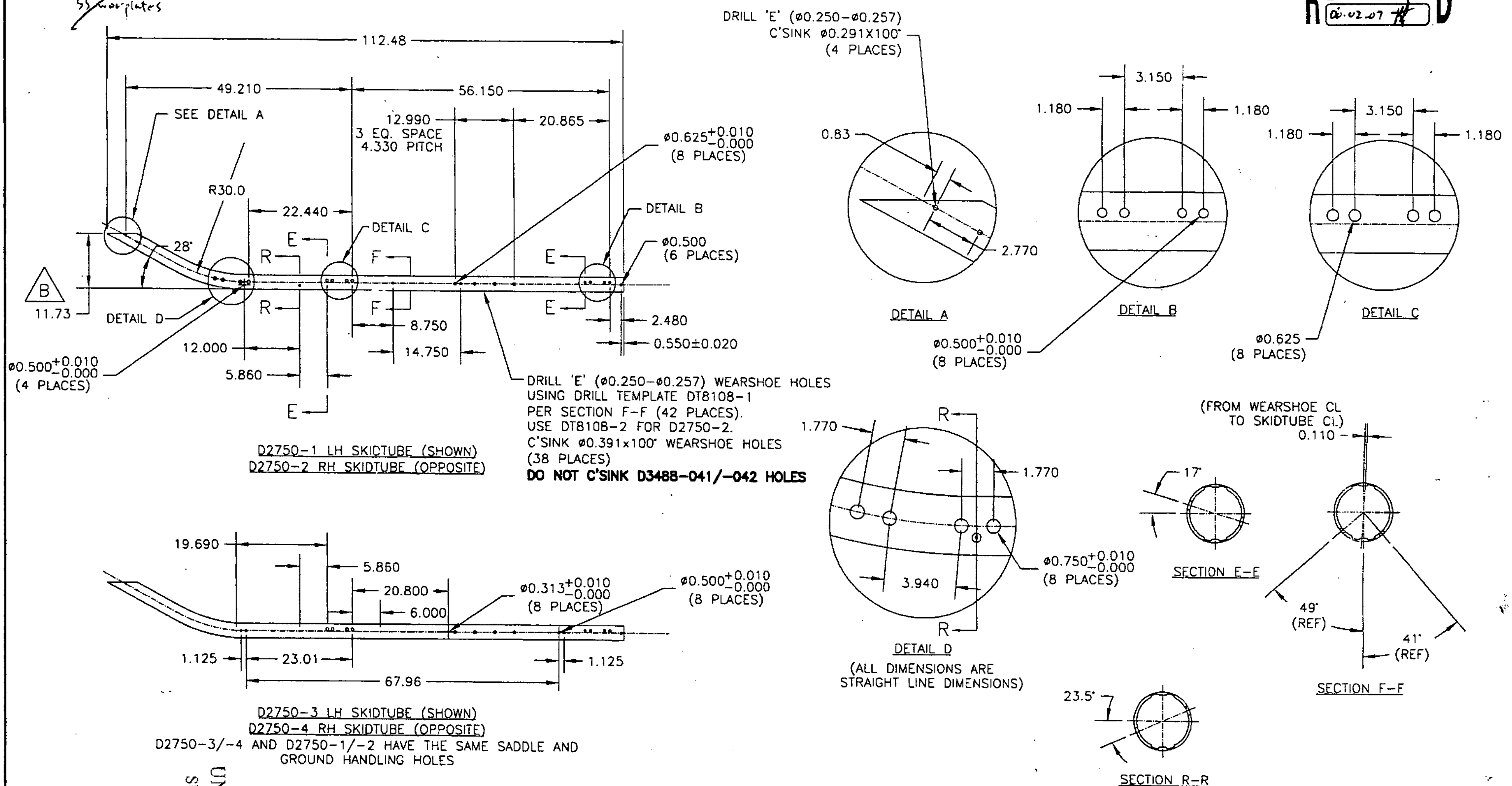
RELEASED

GENERAL NOTES:

1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
   ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES (Ø0.250- Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391 X 100° AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX –241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

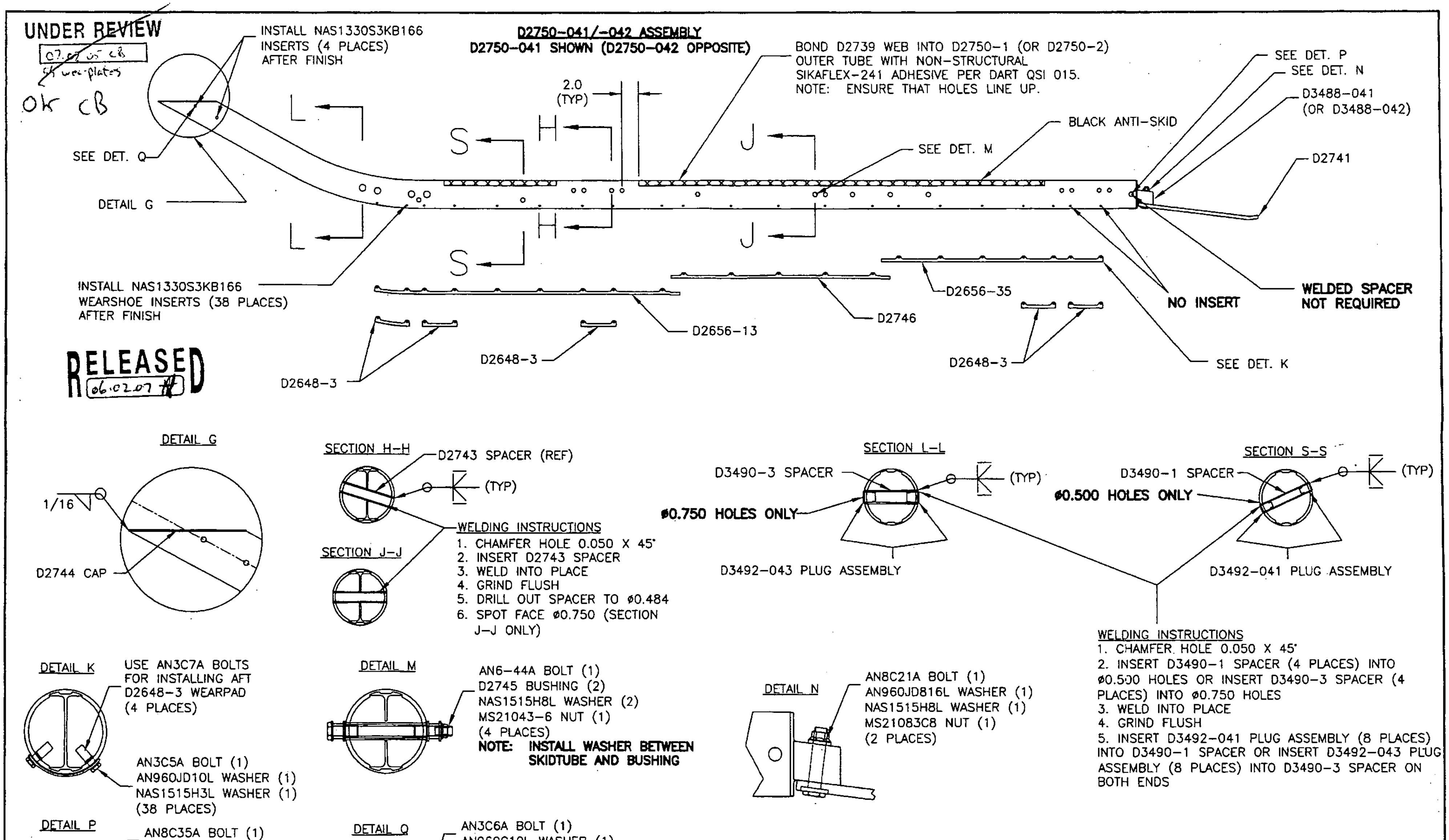
UNDER REVIEW

RELEASED

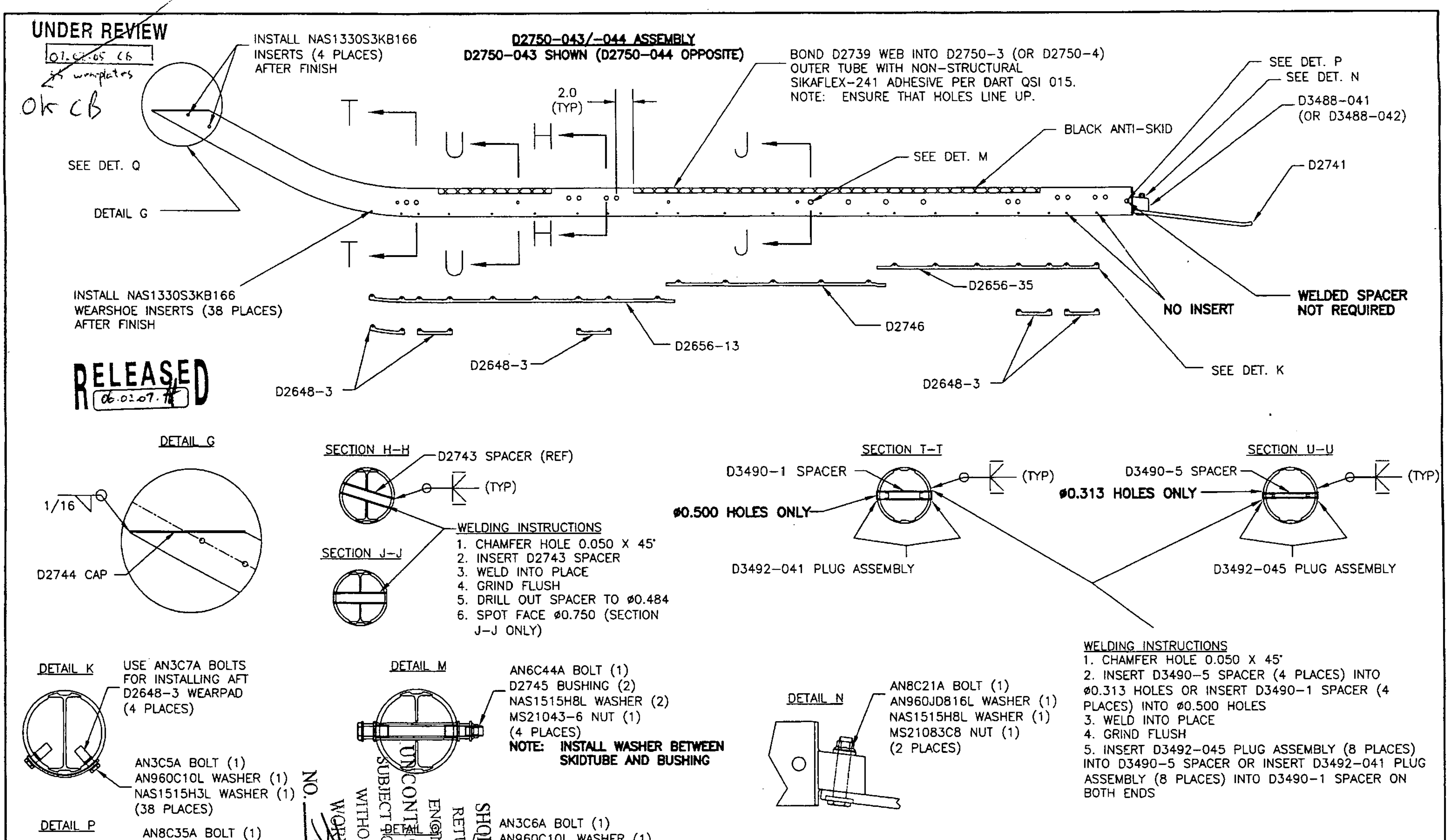


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WORK ORDER
NO.

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 3 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 4 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE 1:20



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
PH	PH	
CHECKED	APPROVED	DRAWING NO. D2750 — REV. D — SHEET 5 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY — SCALE 1:20

NO. 119

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliotte
Joint Welding Procedure tig
Part number and Job number ODSSO 636 OR / B33870

TEST WELDS REQUIRED

BASE METAL Aluminium
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS tig
Single Weld [✓] Double Weld [ ]
Backing YES [ ] NO [✓]

	Position		Vertical Down [ ] Up [ ]	
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [✓]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into ____________ Skidtube

TEST RESULTS

Visual Pass [✓] Fail [ ]
Penetration Pass [✓] Fail [ ]

Crossbolt Spacer Pass [✓] Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 01-07-19 Qualifier [signature]

Dart Aerospace Ltd.

25

Date: Friday, 5/25/2007 8:28:16 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 32635		
Estimate Number	: 10262		
P.O. Number	:	**Part Number**	: D350636011
This Issue	: 5/25/2007 **S.O. No.** :	**Drawing Number**	: D2750 ~~UNDER REVIEW~~ CB 07.05.28
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 32265	**Material**	:
Written By	:	**Due Date**	: 6/20/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.05.28		
Comment	: Est Rev:I 02.09.25 Rearranged procedure stepsKJ Est Rev:J 06-03-23 As per Rev D JLM Est Rev:J 06-07.13 As per dsi9343 EC		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-011 CHG 002 07.06.04

2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	______

3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cap
Batch:__________

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8863 drilling holes labelled "A" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut

REFERENCE ONLY